

Work Order ID 65610

January 20, 2011 11:10:34 AM



Page 1

Item ID: D3909-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Fwd

Start Date: 1/21/11 Start Qty: 6.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *mf*

Date: 11-01-20 Tooling:

Date:

Stop



QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3909

C

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

EP 11/02/01 (6)

110

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg
Trim rivet to 1.185" long

EP 11/02/08 (6)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 11/02/08

(+6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65610

January 20, 2011 11:10:34 AM



Page 2

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Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Fwd

Start Date: 1/21/11 Start Qty: 6.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Identify as per dwg & Stock Location: STO

0.00

Memo

0.00

Packaging

11/2/08

60

SP

140



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

11/02/08

ME 11-02-08

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NOTE: Date & initial all entries

Picklist Print

January 20, 2011 11:10:32 AM

Page 1

Work Order ID: 65610

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 1/21/11





Required Date: 2/04/11

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6 		Manufactured	No			100-	Each	0.0000	1	6			
Lanyard Assembly													
D3909-1 		Manufactured	No			100	Each	11.0000	2	12			
Lug Plate, Fwd Crosstube													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST095	11								
				57824	8								
				59155	2								
				64066	1								
D3909-3 		Manufactured	No			100	Each	7.0000	1	6			
Fwd Lower Attach Arm													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST095	7								
				59442	7								
D3909-5 		Manufactured	No			100	Each	3.0000	1	6			
Eyebolt Stud													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST094	2								
				62492	2								
				ST095	1								
				58240	1								

B65617-6x

EB 11/02/01

EB 11/02/01

B65027 1A

EB 11/02/01

EB 11/02/01

B65629 4x

2

W/O:		WORK ORDER CHANGES					
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Page 2

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Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 1/21/11

Required Date: 2/04/11

Start Qty: 6.00

Required Qty: 6.00

D3910-1

Manufactured No

100

Each

20.0000

2



Crosstube Lug

Location

Loc Qty

Loc Code

st507

20

59708

1

64106

19

D3917-1

Manufactured No

100

Each

60.0000

2



Washer

Location

Loc Qty

Loc Code

ST065

40

57821

40

ST096

20

60170

20

AN3C12A

Purchased No

100

Each

100.0000

4



Bolts

Location

Loc Qty

Loc Code

ST351

100

112314

8

114761

11

116022

2

116289

29

116428

50

12
EP 11/02/08
B59349(IX)

11
EP 11/02/01

12
24
EP 11/02/01

24
116428

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Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 1/21/11

Required Date: 2/04/11

Start Qty: 6.00

Required Qty: 6.00

AN3C13
Bolt

Purchased No

100 Each

64.0000

1

6

Location

Loc Qty

Loc Code

ST351

64

114304

20

114714

44

MS17984-C413
PIN, QUICK RELEASE

Purchased No

100 Each

7.0000

1

6

Location

Loc Qty

Loc Code

ST315

7

116304

7

* MS20615-4M18
RIVET

Purchased No

100 Each

174.0000

3

18

Location

Loc Qty

Loc Code

ST323

174

114808

26

115054

148

AN310C3
Castellated Nut

Purchased No

100 Each

64.0000

1

6

Location

Loc Qty

Loc Code

ST349

64

114304

14

114714

50

W/O:		WORK ORDER CHANGES					
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Work Order ID: 65610

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 1/21/11

Required Date: 2/04/11

Start Qty: 6.00


Required Qty: 6.00

MS21043-3 Purchased No 100 Each 1,677.000 4 24

 Nut


Location	Loc Qty	Loc Code
FG	76	
103691	76	
ST301	1601	
112314	1601	

EP 11/02/01

MS24665-151 Purchased No 100 Each 571.0000 1 6

 Cotter Pin


Location	Loc Qty	Loc Code
ST309	571	
17566	571	

EP 11/02/01

NAS1149C0332R Purchased No 100 Each 4,752.000 8 48

 Washer

Location	Loc Qty	Loc Code
ST297	4752	
115000	125	
115698	35	
116025	1592	
116304	3000	

EP 11/02/01

NAS1149C0363R Purchased No 100 Each 5,369.000 2 12

 Washer

Location	Loc Qty	Loc Code
ST297	5369	
113524	33	
113889	352	
114742	4984	

EP 11/02/01

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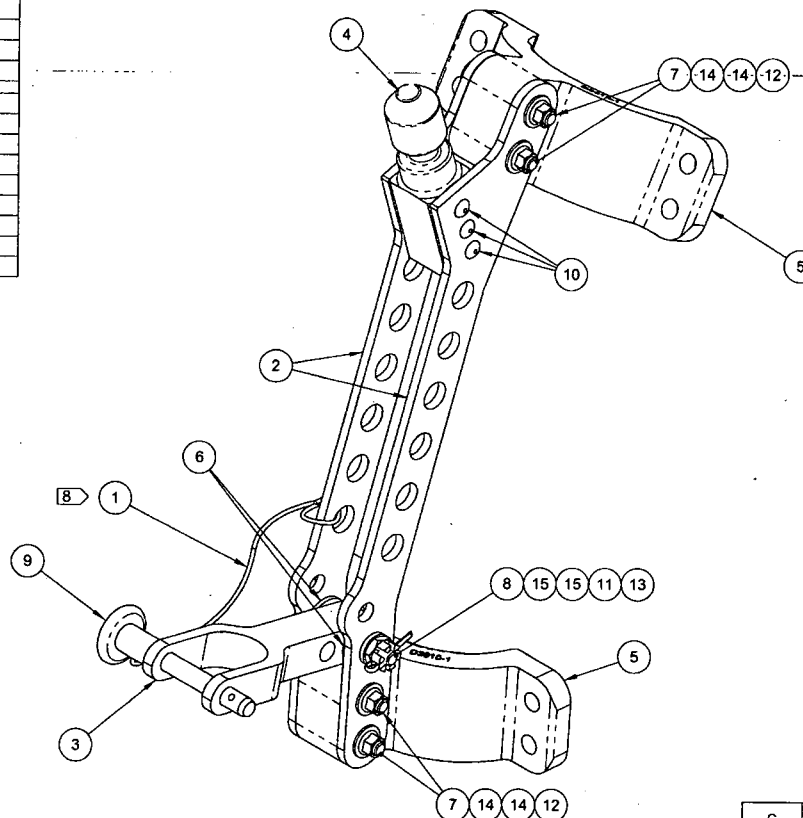
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3909-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	2	D3909-1	FWD X-TUBE LUG PLATE
3	1	D3909-3	FWD LOWER ATTACH ARM
4	1	D3909-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	2	D3917-1	WASHER
7	4	AN3C12A	BOLT
8	1	AN3C13	BOLT
9	1	MS17984-C413	PIP PIN
10	3	MS20615-4M20	RIVET
11	1	AN310C3	NUT - CASTELLATED
12	4	MS21043-3	NUT
13	1	MS24665-151	COTTER PIN
14	8	NAS1149C0332R	WASHER
15	2	NAS1149C0363R	WASHER



D3909-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.81 lbs
- 8) ATTACH D2690-6 TO D3909-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING

#65610

RELEASED
2010-08-04

C	ITEM #4: 1.50 WAS 1.30 (ZN B5-5), 2.68 WAS 2.68 (ZN B6-5); WEIGHT AFFECTED (D3909-041/-5).	MB	10.06.18
B	BOM: ADDED ITEM 15 QTY 2 NAS1149C0363R ADDED, ITEM 14 QTY 8 WAS 10. SHT 5, D3909-5 REVISED. SECTION A-A & DIM Ø0.650 REMOVED. SIDE VIEW ADDED. DIM: 2.68 WAS 2.38 REF. 1.30 WAS 1.00, 0.250 WAS 0.220. R0.06 WAS R0.05. WEIGHT REVISED.	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. C
MFG. APPR.	JPH	D3909	SHEET 1 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	FWD X-TUBE LUG ASSY	NTS
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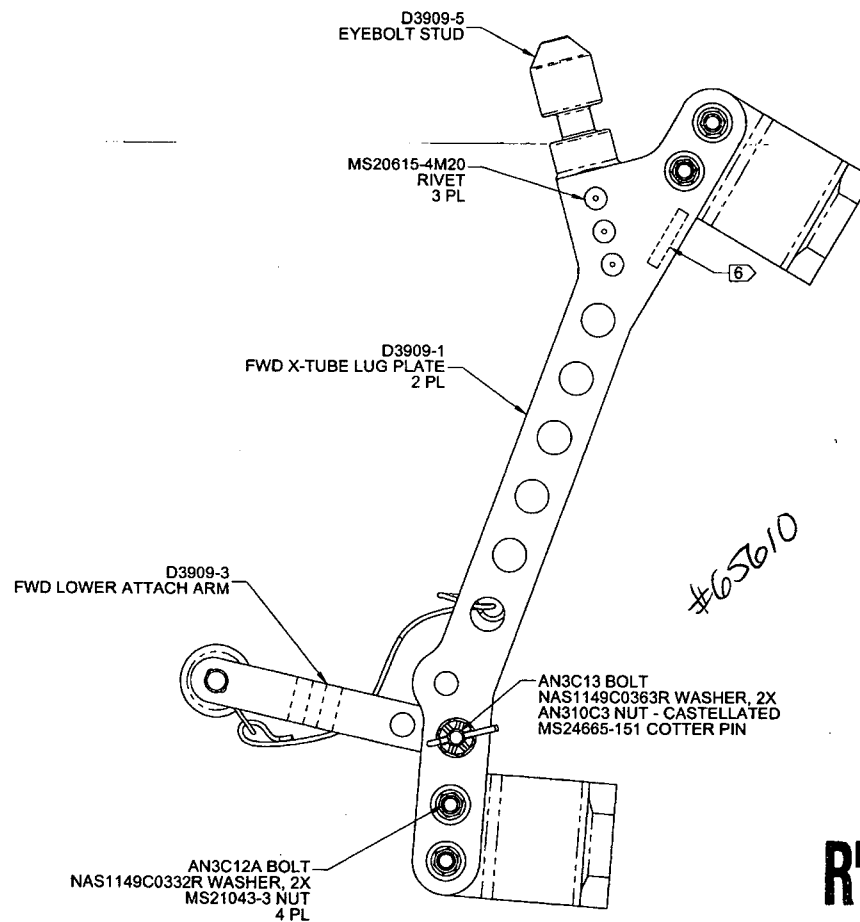
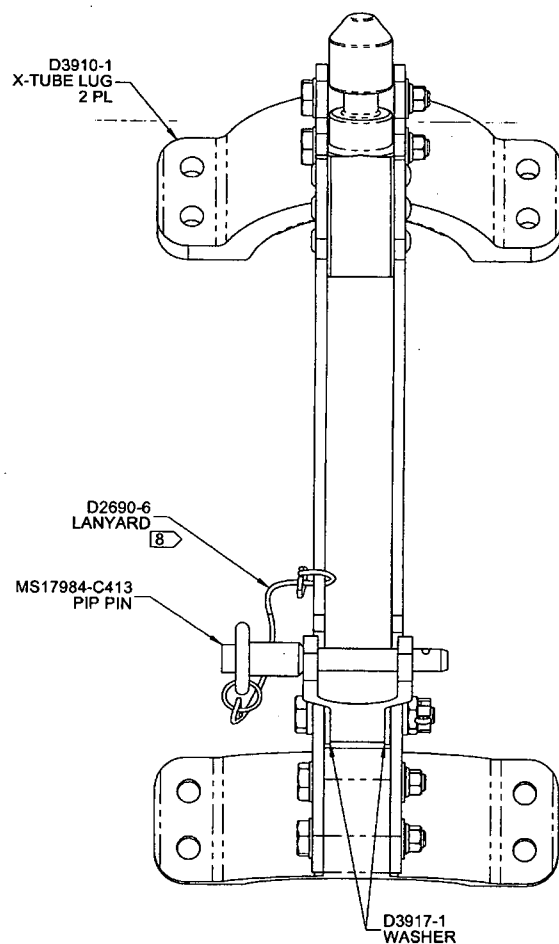
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D3909-041 FWD X-TUBE LUG ASSY

RELEASED
2010-08-04

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO. D3909	REV. C
MFG. APPR.	JPH	SHEET 2 OF 5	
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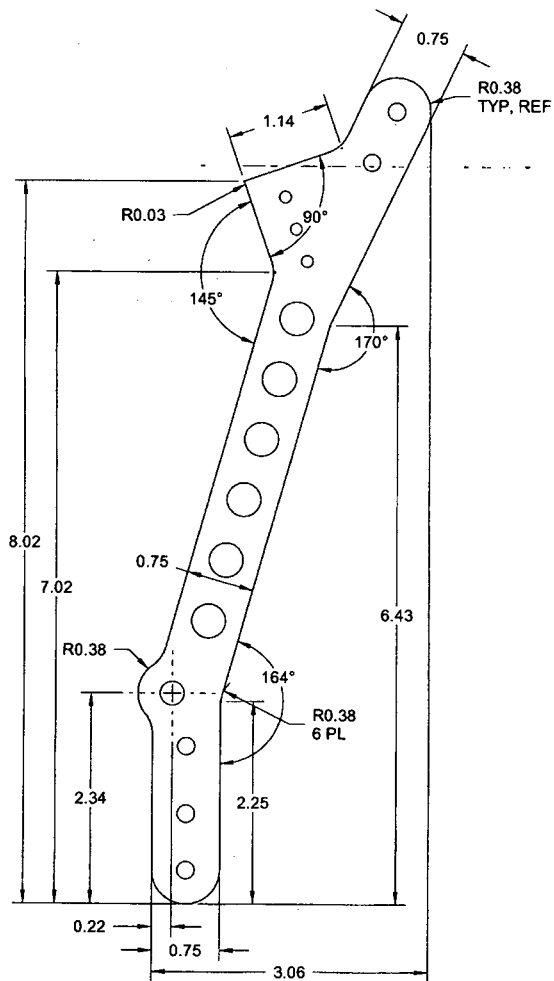
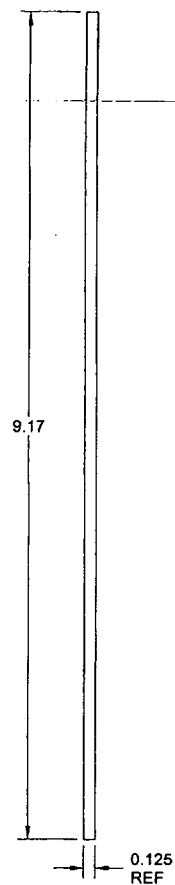
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

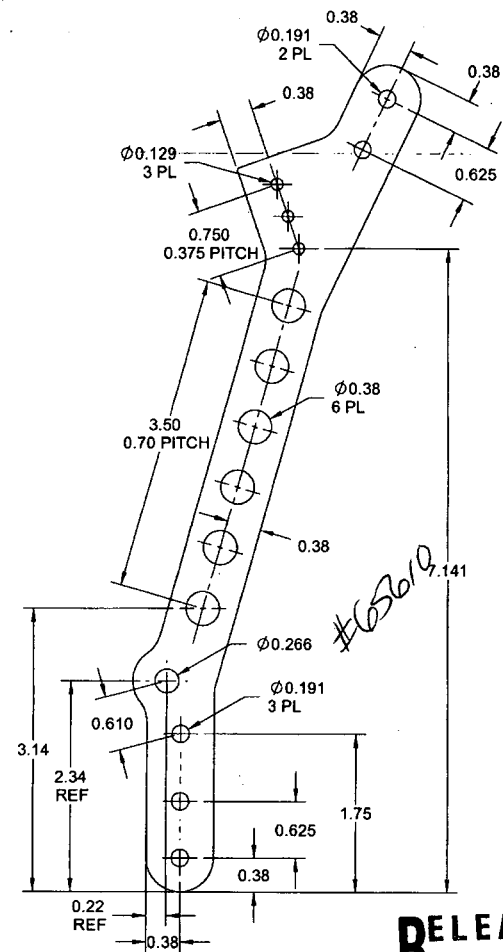
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D3909-1 FWD X-TUBE LUG PLATE



(SUPPLEMENTAL VIEW)

RELEASED
2010-08-01

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.25 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3909	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD X-TUBE LUG ASSY.	NTS
DATE	10.06.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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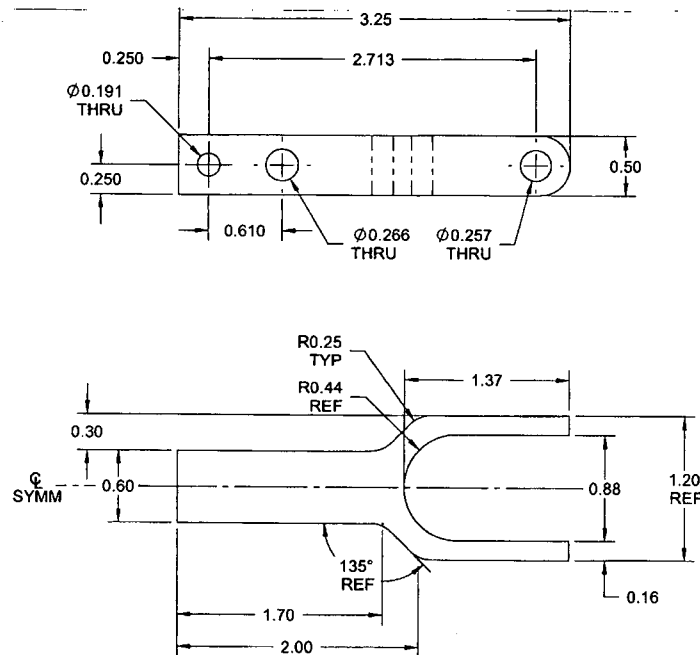
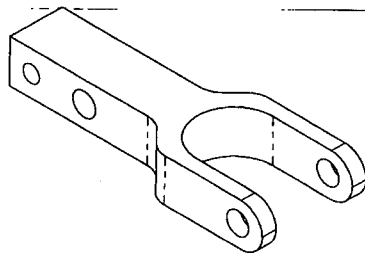
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NOTE: Date & initial all entries



D3909-3 FWD LOWER ATTACH ARM

#65610

RELEASED
2010-08-01

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A582 OR ASTM A276
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3909	SHEET 4 OF 5
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DE APPR.		FWD X-TUBE LUG ASSY	NTS
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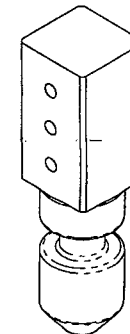
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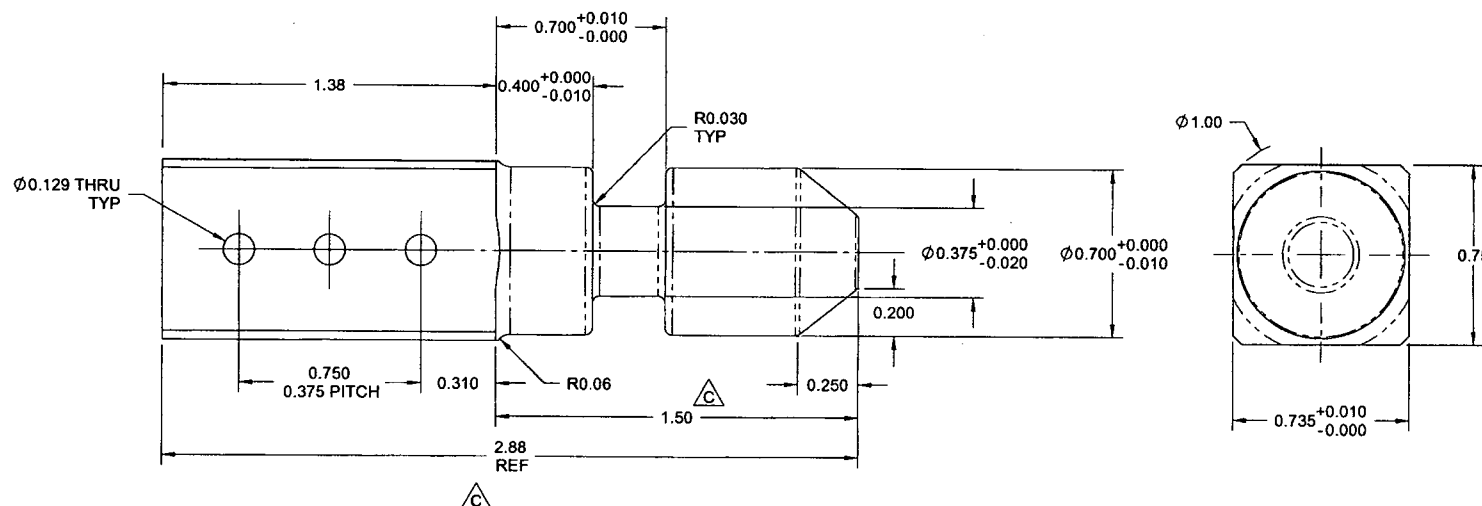
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NOTE: Date & initial all entries



#65610



D3909-5 EYEBOLT STUD

RELEASED
2010-08-04

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR PER ASTM A582 OR ASTM A276 PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.34 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3909	SHEET 5 OF 5
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